

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015172**Date Inspected:** 28-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Jobsite**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS OBG**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance Inspector (QAI) Bert Madison was present at Yerba Buena Island in California between the times noted above for observations relative to the work being performed by American Bridge/Fluor Enterprises (AB/F) personnel at the locations noted below.

- 1). OBG Field Splice 3E/4E Welds D1 & D2, Face B (QC)
- 2). OBG Field Splice 3E/4E Welds D1 & D2, Face B (QA)
- 3). OBG Field Splice 4W/5W Weld A6, Face A
- 4). OBG Field Splice 1W/2W Welds D1 & D2, Face B
- 5). OBG Field Splice 3W/4W Welds C1 & C2, Face B

- 1). OBG Field Splice 3E/4E weld ID: D1 & D2, Face B

The QAI observed ABF QC personnel (Bonafacio Daquinag & Jesse Cayabyab) performing Visual and Magnetic Particle Testing of the flush ground surfaces of the OBG field splice and the temporary attachment removal areas. The work at this location was completed during the QA Inspectors shift. See photo below.

- 2). OBG Field Splice 3E/4E weld ID: D1 & D2, Face B. The QAI performed verification visual & magnetic particle testing of 10% of the lengths of welds D1 & D2. The QAI inspected 425mm of Weld D1 from Y = 3825mm to Y = 4250mm and 800mm of weld D2 from Y = 4250mm to Y = 5050mm. The welds verified by the QAI were found to be in general compliance with contract documents. See Report of Magnetic Particle Testing Form TL-6028 generated by the QAI on this date.

- 3). Field Splice 4W/5W weld ID: A1 Face A.

The QAI periodically observed the in process welding of a 100mm long UT repair located at Y = 5110mm, per the

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## WELDING INSPECTION REPORT

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Flux Cored Welding (FCAW-G) process in the 1G (flat) position by ABF welding personnel Xiao Jian Wan (ID 9677). QC Inspector Bonafacio Daquinag was present to monitor the progress and verify that the welding parameters were within the limits established by the approved welding Procedure Specification (WPS) identified as ABF-WPS-D1.5-3000-1. The QAI observed that the welding parameters appeared to be in general compliance with the contract documents. The welding at this location was in progress for the remainder of the QA Inspectors shift. See photo of excavation below.

#### 4). OBG Field Splice 1W/2W Face D (outside)

The QAI periodically observed ABF personnel performing Plasma Cutting to remove the backing bar and subsequent grinding to prepare the groove for back welding. The work at this location was in process for the remainder of the QA Inspectors shift.

#### 5). OBG Field Splice 3W/4W

##### Face C (outside)

The QAI periodically observed that ABF personnel completed Plasma Cutting to remove the backing bar and subsequent grinding to prepare the groove for back welding was in process. The work at this location was in process for the remainder of the QA Inspectors shift.

##### Face E (outside)

The QAI observed that ABF personnel had completed final grinding.



### Summary of Conversations:

None of relevance.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mohammed Fatemi (916) 813 3677, who represents the Office of Structural Materials for your project.

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**Inspected By:** Madison,Bert

Quality Assurance Inspector

**Reviewed By:** Levell,Bill

QA Reviewer

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